

Date: Tuesday, 8/21/2007 3:42:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 34171	
Estimate Number : 10615	
P.O. Number : N/A	Part Number : D265623
This Issue : 8/21/2007 S.O. No. : N/A	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 32580	Material : N/A
Written By : <u>LD 07.08.22</u>	Due Date : 9/10/2007 Qty: 20 Um: Each
Checked & Approved By : <u>LD 07.08.22</u>	
Comment : Est: D 02.10.25 Re-format KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 1.4800 sf(s)/Unit Total : 29.5995 sf(s)

1018 20 GA .040" THK

Batch: M105671 LB 07-09-21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: D

Prog Rev: D

LB 07-09-21

(22)

2-Deburr if necessary

LB 07-09-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



LB 07-09-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



counts

Comment: SECOND CHECK

En 21/09/21

(22)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-23

LB 07/09/25

(22)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/10/2008  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:42:47 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34171

Part Number: D265623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*ceants*

Comment: INSPECT WORK TO CURRENT STEP

*Er 06/09/25*

*(22)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*FX*

*07/09/26*

*(22)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*HL 07-09-27*

*(22)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*FP-18*

*FX*

*07/09/27*

*(22)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*207/09/28*

Job Completion



*U 07-09-28*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	34171
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D2656-23
<b>Inspection Dwg:</b> D2656 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.850	+/-0.010	52.850	*			
48.200	+/-0.010	48.200	*			
44.700	+/-0.010	44.700	*			
39.310	+/-0.010	39.310	*			
33.920	+/-0.010	33.920	*			
28.530	+/-0.010	28.530	*			
23.140	+/-0.010	23.140	*			
17.750	+/-0.010	17.750	*			
14.250	+/-0.010	14.250	*			
9.500	+/-0.010	9.500	*			
4.750	+/-0.010	4.750	*			
2.000	+/-0.010	2.000	*			
2.000	+/-0.010	2.000	*			
1.885	+/-0.010	1.886	*			
0.300	+/-0.010	.303	*			
0.300	+/-0.010	.303	*			
0.040	+/-0.010	.041	*			

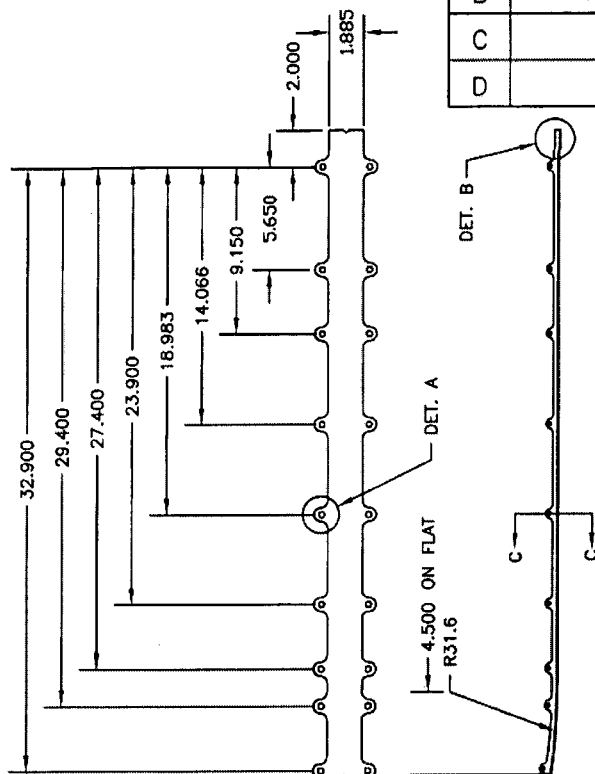
<b>Measured by:</b>	R	<b>Audited by:</b>	En	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07-09-21	<b>Date:</b>	07/09/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

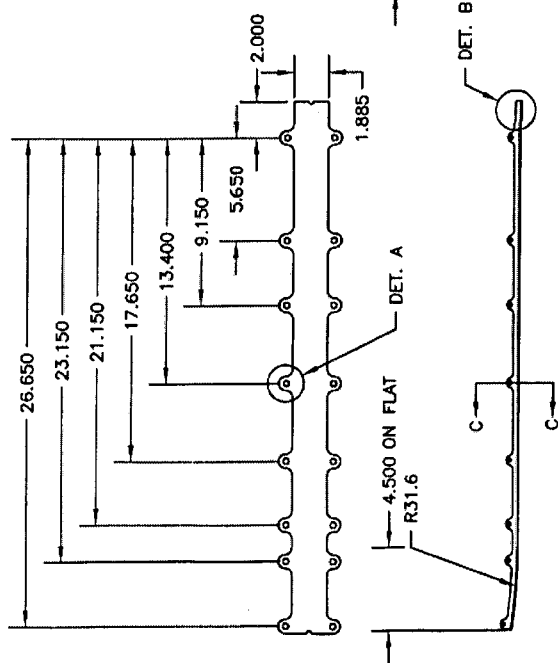


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				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

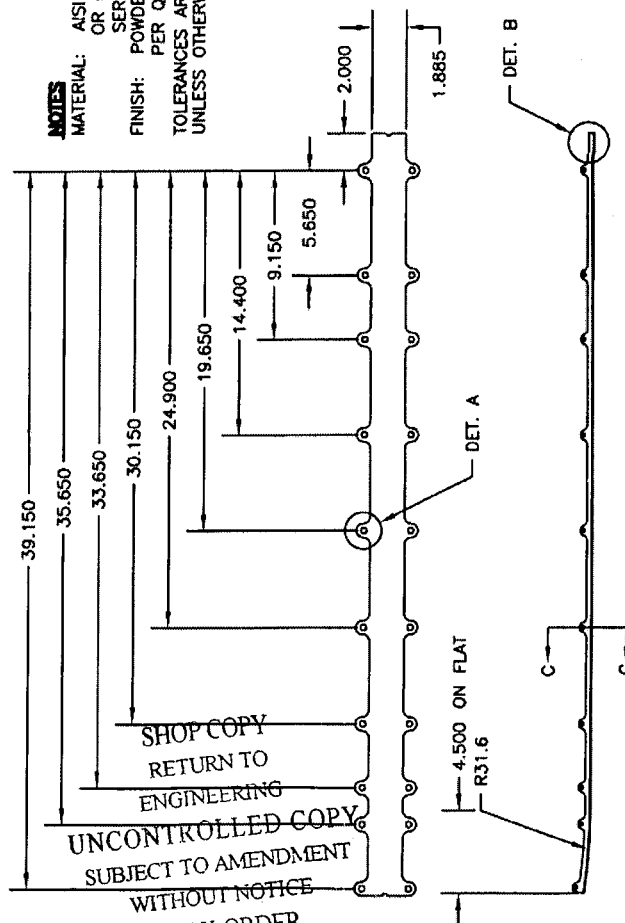
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**D2656-11**



**D2656-15**



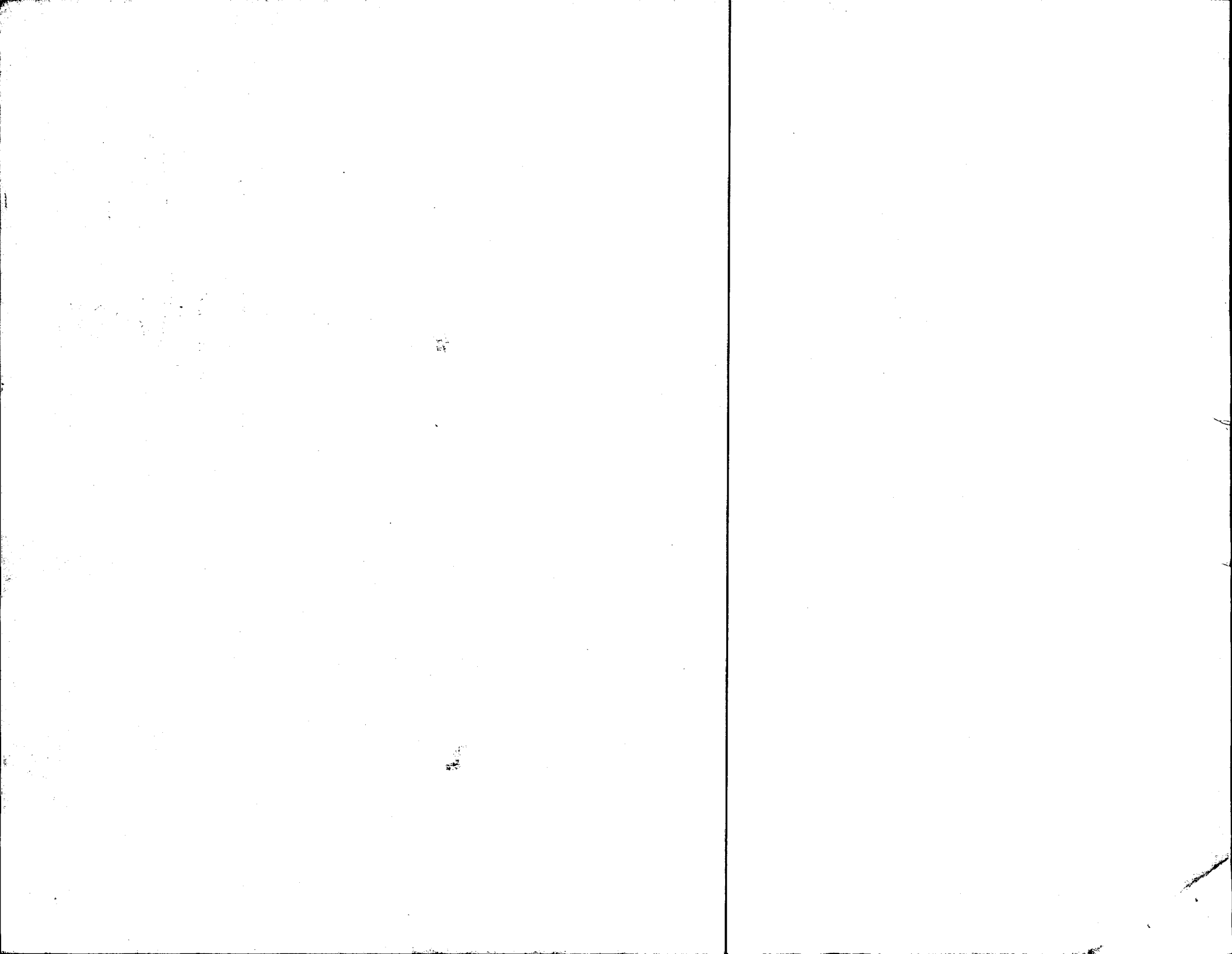
**NOTES:**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
 PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

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 05.09.02

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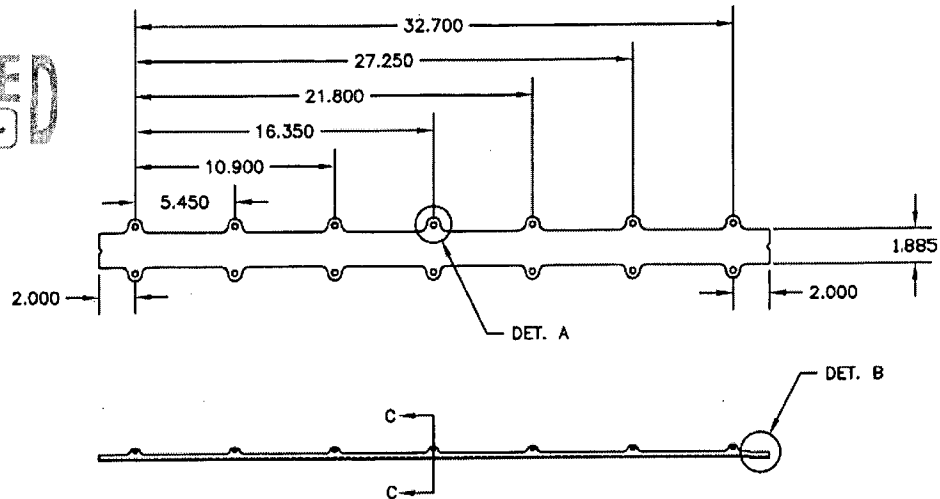




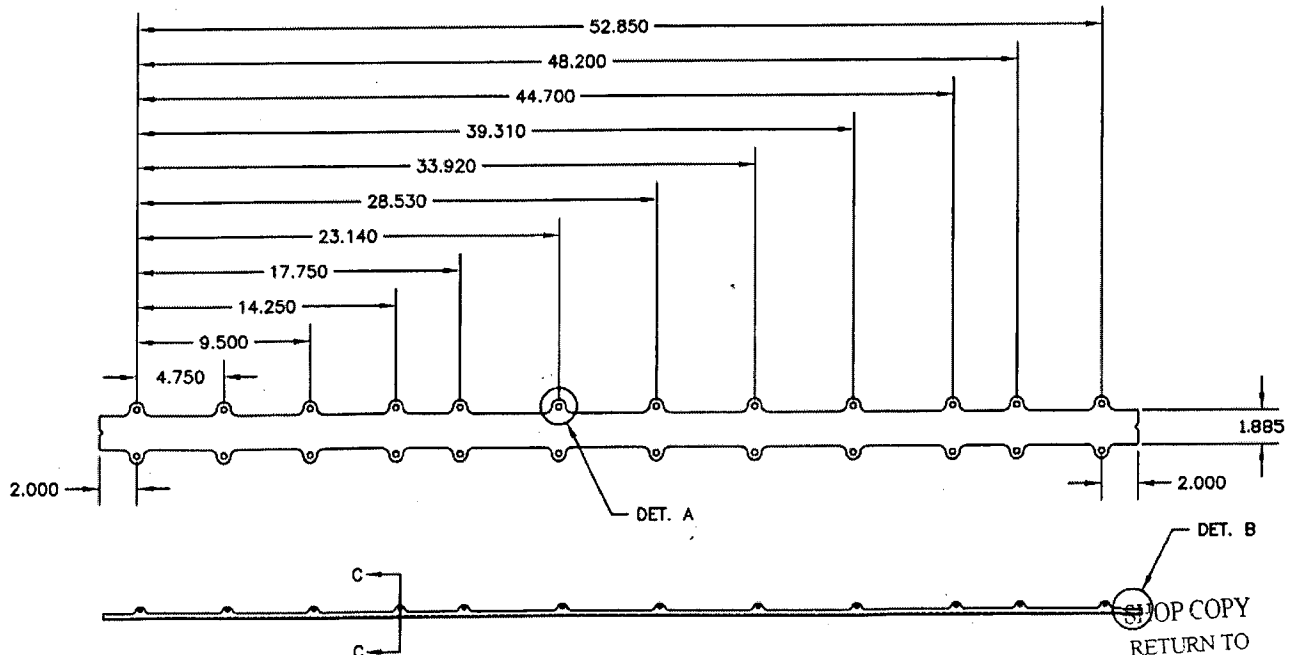
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05-07-06 *[Signature]*

**D2656-21**



**D2656-23**



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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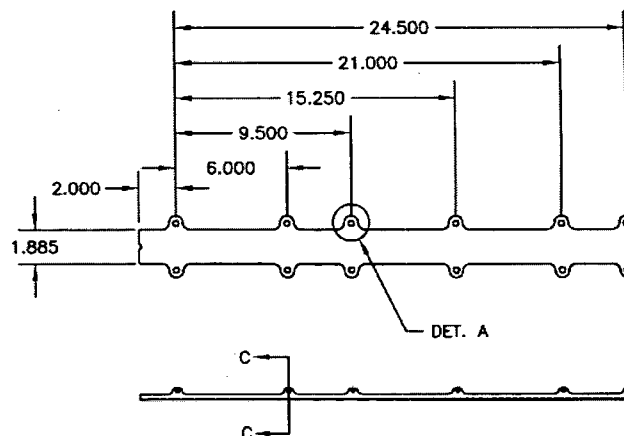
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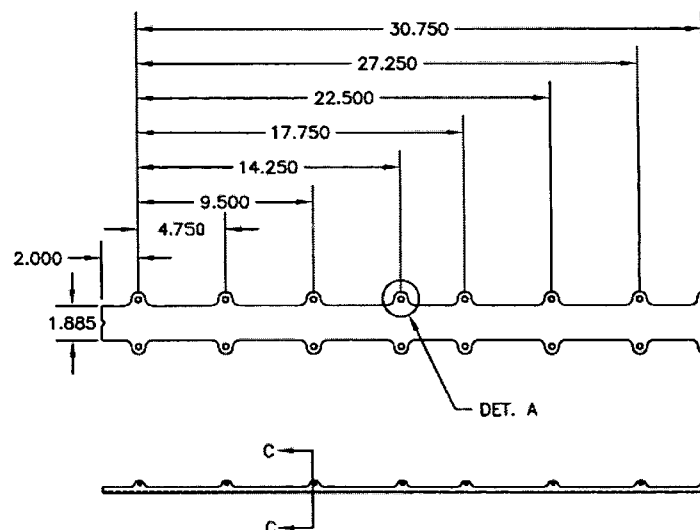
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DATE	05.08.17	TITLE	WEARSHOE	SCALE	1:10

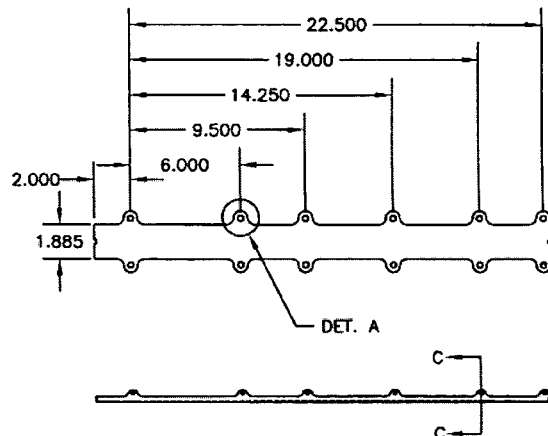
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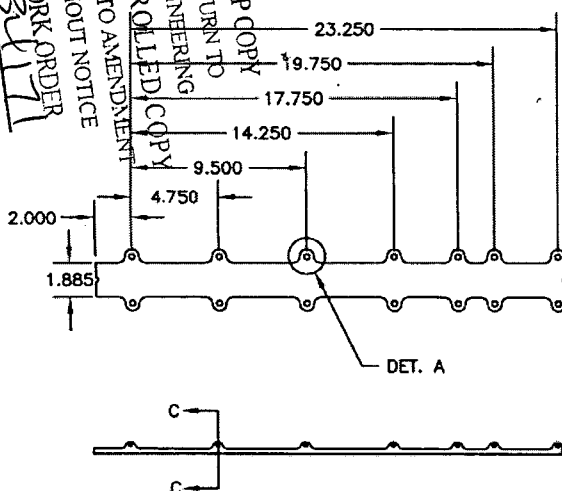
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**D2656-31**



**D2656-35**



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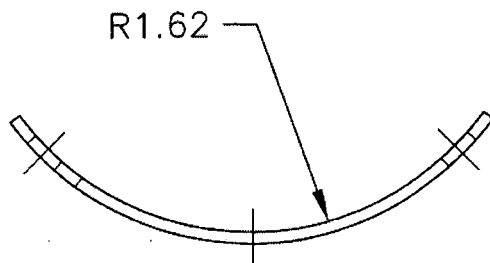
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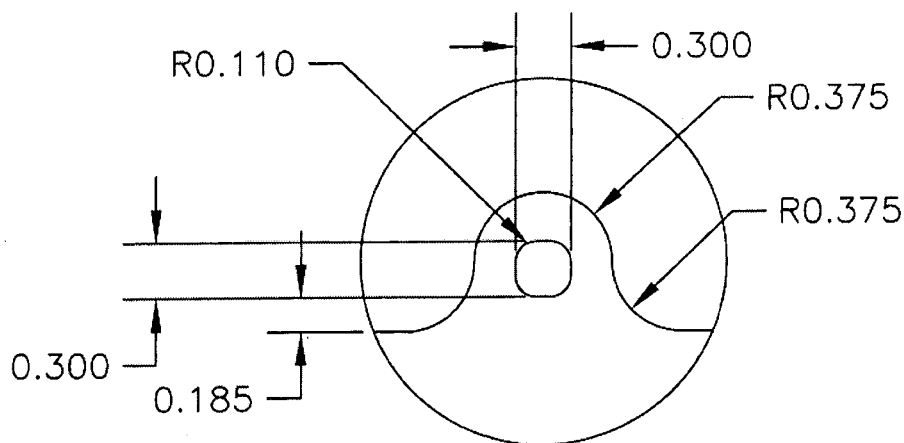
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

### SECTION C-C

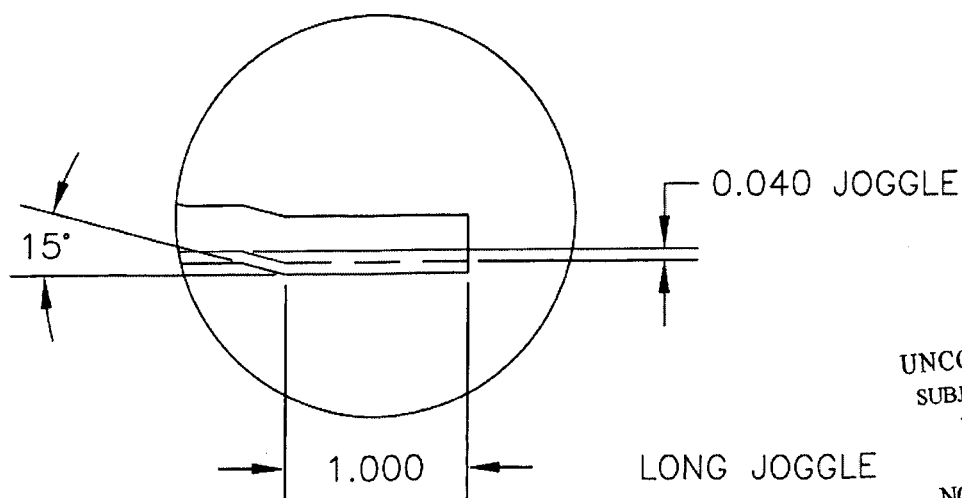


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### DETAIL A



### DETAIL B



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